



Dart Aerospace Ltd.
1270 Aberdeen St
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Canada

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D3808-1
Job Sheet 200662



Part No: D3808-1

Part Name: Seat Rail

Job Qty: 10 pcs



Part Weight: 0 lbs

Job Created: 9/13/19

Due Date: 10/14/19

Type: Stock

Status: New

Job Tracking No:

Priority: Medium

Created By: Jennifer Renwick

Description:

Note: DWG REV A IPP Rev:A New Issue 08-07-31 JLM Verified By:DD
Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Bandsaw - 1	10 pcs		10/14/19	0.00	0.02	Bandsaw - 1	DAS 1.2	19/10/23 19/10/23
110	HAAS 4 Axis - B4B	10 pcs		10/14/19	0.29	15.38	HAAS - 1 - B4B	DAS 9.89	
							HAAS - 2 - B4B	52	
							HAAS - 3 - B4B	9-89	
							HAAS - 4 - B4B		
120	QC 2	10 pcs		10/14/19	0.00	0.00	QC 2 - 1		
							QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		
							QC 2 - 49		
							QC 2 - 50		



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Container No: S219283



Part: D3808-1

Job No: 200662

Serial No/Batch: S219283

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

Date: 10/03/19

						QC 2 - 51	DAS	19/10/03
						QC 2 - 52	52	
						QC 2 - 57	9-89	
						QC 2 - 62		
						QC 2 - 63		
						QC 2 - 8		
						QC 2 - 66		
						QC 2 - 64		
						QC 2 - 65		
						QC 2 - 5		
						QC 2 - 71		
						QC 2 - 73		
						QC 2 - 69		
						130 QC 8	10 pcs	
QC 8 - 14								
QC 8 - 17								
QC 8 - 20								
QC 8 - 25								
QC 8 - 3								
QC 8 - 32								
QC 8 - 33								
QC 8 - 35								
QC 8 - 39								
QC 8 - 4								
QC 8 - 44								
QC 8 - 45								
QC 8 - 49								
QC 8 - 58								
QC 8 - 8								
QC 8 - 9								
QC 8 - 68								
QC 8 - 67								
QC 8 - 1 (A)								
QC 8 - 47								
QC 8 - 40								
QC 8 - 52								
QC 8 - 23								
QC 8 - 57								
QC 8 - 76								
140 Handfinish - 1-1 Chemical-B4B	10 pcs	10/14/19	0.00	0.71	Handfinish - 1 - 1 - B4B			
					Handfinish - 1 - 2 - B4B			
					Handfinish - 1 - 3 - B4B			
					Handfinish - 1 - 4 - B4B			
					Handfinish - 1 - 5 - B4B			
					Handfinish - 1 - 6 - B4B			
					Handfinish - 1 - 7 - B4B			
					Handfinish - 1 - 8 - B4B			
					Handfinish - 1 - 9 -			

				B4B	
				Handfinish - 1 - 10 - B4B	
				Handfinish - 1 - 11 - B4B	
				Handfinish - 1 - 12 - B4B	
				Handfinish - 1 - 13 - B4B	
				Handfinish - 1 - 14 - B4B	
				Handfinish - 1 - 15 - B4B	
				Handfinish - 1 - 16 - B4B	
				Handfinish - 1 - 17 - B4B	
				Handfinish - 1 - 18 - B4B	
				Handfinish - 1 - 19 - B4B	
				Handfinish - 1 - 20 - B4B	
				Handfinish - 1 - 21 - B4B	
				Handfinish - 1 - 22 - B4B	
141 QC 7	10 pcs	10/14/19	0.00 0.00	QC 7 - 10	
				QC 7 - 13	
				QC 7 - 14	
				QC 7 - 15	
				QC 7 - 17	
				QC 7 - 18	
				QC 7 - 19	
				QC 7 - 2	
				QC 7 - 28	
				QC 7 - 3	
				QC 7 - 30	
				QC 7 - 34	
				QC 7 - 36	
				QC 7 - 37	
				QC 7 - 41	
				QC 7 - 47	
				QC 7 - 48	
				QC 7 - 51	
				QC 7 - 58	
				QC 7 - 59	
				QC 7 - 60	
				QC 7 - 9	
				QC 7 - 68	
				QC 7 - 50	
				QC 7 - 67	
				QC 7 - 40	
				QC 7 - 24	
				QC 7 - 43	
				QC 7 - 61	
				QC 7 - 81	

DAS
40
9-89
OCT 07 2019

				QC 7 - 76		
150	Packaging 3-1 - Stock - B4B	10 pcs	10/14/19	0.00	0.00	Packaging 3 - 1 - B4B
						Packaging 3 - 2 - B4B
						Packaging 3 - 3 - B4B
						Packaging 3 - 4 - B4B
						Packaging 3 - 5 - B4B
						Packaging 3 - 6 - B4B
						Packaging 3 - 7 - B4B
						Packaging 3 - 8 - B4B
						Packaging 3 - 9 - B4B
						Packaging 3 - 10 - B4B
						Packaging 3 - 11 - B4B
						Packaging 3 - 12 - B4B
						Packaging 3 - 13 - B4B
						Packaging 3 - 14 - B4B
						Packaging 3 - 15 - B4B
						Packaging 3 - 16 - B4B
						Packaging 3 - 17 - B4B
						Packaging 3 - 18 - B4B
						Packaging 3 - 19 - B4B
						Packaging 3 - 20 - B4B
						Packaging 3 - 21 - B4B
						Packaging 3 - 22 - B4B
						Packaging 3 - 23 - B4B
						Packaging 3 - 24 - B4B
						Packaging 3 - 25 - B4B
						Packaging 3 - 26 - B4B
						Packaging 3 - 27 - B4B
						Packaging 3 - 28 - B4B
						Packaging 3 - 29 - B4B
						Packaging 3 - 30 - B4B
						Packaging 3 - 31 - B4B
						Packaging 3 - 32 - B4B
						Packaging 3 - 33 - B4B
						Packaging 3 - 34 -

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				B4B		
				Packaging 3 - 35 - B4B		
				Packaging 3 - 36 - B4B		
160 QC 21 - SA	10 pcs	10/14/19	0.00	0.00	QC 21 - SA - 21	Dag
					QC 21 - SA - 70	21
					QC 21 - SA - 53	0.00
Part Op 100 - (Bandsaw) Cut blank 16.125 " long Descriptions: 110 - (HAAS CNC Vertical Machine) 1- Mill as per Folio FA771Rev: AA & Dwg D3808 Rev: A 2-Tap holes for 8-32" Helicoil 3-Tap holes for 3/8-16 Helicoil 4-Deburr per dwg D3808 120 - (QC2- Inspect parts off machine FAI/FAIB) 130 - (QC8- Inspect parts - second check) 140 - (Chemical Conversion Coat per QSI005 4.1) 141 - (QC7- Inspect Chemical Conversion Coat) 150 - (Identify as per dwg & Stock Location: _____) 160 - (QC21- Final Inspection - Work Order Release)						
Job BOM						
Part / Item	Component Name	Quantity	Operation	Container		
M6061T6B2.000X01.250	6061-T6 Bar 2.00 X 1.25 see mat'l	13.5000 ft (1.35 ea)	100-Bandsaw -	5216003		
	M6061T6B1.250X2.000		4	13.5 ft		
Job Allocations						
Operation	Component Part	Required	Inventory	Allocated		
100-Bandsaw - 1	M6061T6B2.000X01.250	14	4	0		
Part Specifications						
Specifications could not be found.						

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H:/FORMS/Quality Assurance\approved QA/NCRWO Rev J

DART AEROSPACE LTD		Work Order: 200662
Description: Seat Rail		Part Number: D3808-1
Inspection Dwg: D3808	Rev: A	Page 1 of 2

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
14.000	+/-0.010	14.000	✓		Machine	
7.30	+/-0.030	7.300	✓		Vern.	
0.550	+/-0.010	0.549	✓		Vern.	
0.85	+/-0.030	0.849	✓		Vern.	
0.780	+/-0.010	0.780	✓		Vern.	
Ø0.391	+0.006/-0.001	0.392	✓		Vern.	
3/8-16 UNC	N/A	3/8-16	✓		Go/NoGo	
Ø0.323	+0.006/-0.001	0.326	✓		Vern.	
Ø0.695 x 100°	+/-0.010 x 0.5°	0.690 x 100°	✓		Vern.	
Ø0.172	+0.005/-0.001	0.172	✓		Vern.	
8-32 UNC	N/A	8-32	✓		Go/NoGo	
0.800 x 0.667 deep	+/-0.010	0.800 x 0.669	✓		Vern.	
2.00	+/-0.030	2.00	✓		Vern.	
R0.26	+/-0.030	0.260	✓		R.G.	
6.13	+/-0.030	6.128	✓		Vern.	
5.13	+/-0.030	5.128	✓		Vern.	
0.16	+/-0.030	0.158	✓		Vern.	
1.75	+/-0.030	1.749	✓		Vern.	
15.88	+/-0.030	15.880	✓		H.G.	
0.965	+/-0.010	0.962	✓		Vern.	
0.375	+/-0.010	0.372	✓		Vern.	
1.10	+/-0.030	1.099	✓		Vern.	
0.140	+/-0.010	0.142	✓		Micro. M.	
0.373	+/-0.010	0.371	✓		Micro. M.	
0.030 x 45°	+/-0.010 x 0.5°	0.035 x 45°	✓		Vern.	
R0.06	+/-0.030	0.062	✓		R.G.	
0.347	+/-0.010	0.343	✓		Vern.	
0.270	+0.030/-0.000	0.273	✓		H.G.	
Ø0.720	+0.005/-0.010	0.7205	✓		Micro. M.	
R0.063	+/-0.010	0.0625	✓		R.G.	
0.320	+0.020/-0.000	0.321	✓		G. Blocks	
R0.015	+/-0.010	0.005	✓		Vern.	
0.655	+0.015/-0.010	0.652	✓		Vern.	
0.350	+/-0.010	0.350	✓		G. Pin	
0.030 x 45°	+/-0.010 x 0.5°	0.038 x 45°	✓		Vern.	
0.667	+/-0.010	0.669	✓		Vern.	